

5/05

DART AEROSPACE LTD	Work Order:	22089
Description: 407 Utility Basket	Part Number:	D407-663-011
Dwg: D2955 Rev. B	Qty:	1
Ref: ICA-D407-663 Rev. 0 page 27		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D407-663-011 407 Utility Basket D2948-041 407 Basket Base D2952-041 407 Basket Lid			
		Batch 22089 22089 22089			
2	DC	Photocopy bluefile and create labels per PPP D407-663-011 CHG002			
		nk 3			
3	FP	Powder Coat Gloss White (Ref: 4.3.5.2) D2948-041 Base and Powder Coat Gloss White (Ref: 4.3.5.1) D2952-041 Lid as per QSI 005 4.3.			
4	QC3	Inspect Powder Coat			
5	GA	Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024 Pick: D2728-3			
		Qty Part Number Description Batch			
		1 D2332-041 Prop Assembly B23116			
		1 D2530 Handle Weldment B23533			
		2 D2535 Spring B22760			
		2 D2537 Bushing B23448			
		1 D2851-145 Placard B21197			
		2 D2931 Bumper B21139			
		1 D2961 Placard B12077			
		2 AN3-20A Bolt M15432			
		2 AN4-14A Bolt M15072			
		2 AN4-22A Bolt M15387			
		2 AN5-17A Bolt M16273			
		2 AN5-21A Bolt M10538			
		4 AN960JD416 Washer M17506			
		4 AN960JD516 Washer M17614			
		2 AN960JD8 Washer M10158			
		4 AN970-4 Washer M16895			
		2 MS20600AD4W3 Rivet M13267			
		2 MS21042L3 Nut (or -3) M15524			
		4 MS21042L4 Nut (or -4) M17492			
		4 MS21042L5 Nut (or -5) M17653			
		Identify as D2955-041			
6	QC5	Inspect work to Step 5			

RCP 0600513

As

RELEASED
04.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/10/06	5	Permanent change & UPDATE DWG. 2 AN 9605D 416L 4 AN 9605D 416	JB	05/10/06		JB 05.10.06	 05.10.06

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22089
Description: 407 Utility Basket		Part Number:	D407-663-011
Dwg: D2955 Rev. B		Qty:	1
Ref: ICA-D407-663 Rev. 0 page 27		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																																								
7	KP	<p>Pick: Packing Kit (Note: D2955-041 is on BOM as parts listed in Step 5).</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2852</td><td>Label</td><td>B23141</td></tr><tr><td>1</td><td>D2955-041</td><td>Basket Assembly</td><td>B22089</td></tr><tr><td>1</td><td>D2984</td><td>Label</td><td>B12405</td></tr><tr><td>1</td><td>D407-301-011</td><td>Center Bracket Kit</td><td>B22090</td></tr><tr><td>1</td><td>D407-302-011</td><td>Outboard Bracket Kit</td><td>B21172</td></tr><tr><td>6</td><td>AN3-11A</td><td>Bolt</td><td>m4067</td></tr><tr><td>6</td><td>AN960JD10</td><td>Washer</td><td>m18359</td></tr><tr><td>6</td><td>MS21042L3</td><td>Nut (or -3)</td><td>m15924</td></tr><tr><td>1</td><td colspan="3">paperwork package from step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2852	Label	B23141	1	D2955-041	Basket Assembly	B22089	1	D2984	Label	B12405	1	D407-301-011	Center Bracket Kit	B22090	1	D407-302-011	Outboard Bracket Kit	B21172	6	AN3-11A	Bolt	m4067	6	AN960JD10	Washer	m18359	6	MS21042L3	Nut (or -3)	m15924	1	paperwork package from step 2					
Qty	Part Number	Description	Batch																																										
1	D2852	Label	B23141																																										
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6	MS21042L3	Nut (or -3)	m15924																																										
1	paperwork package from step 2																																												
8	QC4	Inspect Kit 100% for Completeness on the W/O	CD	05/10/06	1																																								
9	PK	Identify and pack for shipping as per PPP D407-663-011 REV.C	CD	05/10/06	1																																								
10	AC	Cost / part 2154.44	SAC	05-10-07	1																																								
11	DC	Close W/Order and Ensure Travellers Attached Inspect Level 21 2154.44 Travellers: D407-663-011 D2948-041 D2952-041	CD	05/10/07	1																																								

Rev	Date	Change	Revised By	Approved
A	00.03.23	New Issue	EC	
B	00.07.06	Added K10001	EC	
C	00.08.10	Added D2984 (mpp 2080)	EC	
D	01.03.08	Changed pick list (mpp 2119)	EC	
E	03.11.26	Reformat; Incorporated D2955-041	KJ/RF	

RELEASED
04.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2955	REV. B SHEET 1 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY	SCALE NTS
A	00.01.13	NEW ISSUE	
B	00.07.17	UPDATE TOP VIEW OF BASKET	

Qty -041	Part Number	Description
X	D2955-041	BASKET ASSEMBLY
1	D2332-041	LID PROP ASSEMBLY
1	D2530	HANDLE WELDMENT
2	D2535	SPRING
2	D2537	BUSHING
1	D2851-145	PLACARD
1	D2961	PLACARD
2	D2931	BUMPER
1	D2948-041	BASKET BASE ASSEMBLY
1	D2952-041	BASKET LID ASSEMBLY
2	AN3-20A	BOLT
2	AN4-14A	BOLT
2	AN4-22A	BOLT
2	AN5-17A	BOLT
2	AN5-21A	BOLT
6	AN960JD416	WASHER
4	AN960JD516	WASHER
2	AN960JD8	WASHER
4	AN970-4	WASHER
2	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
4	MS21042L4	NUT (OR MS21042-4)
4	MS21042L5	NUT (OR MS21042-5)

#00.09.08
RF

#00.09.08
RF

#00.09.08
RF

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WITHOUT NOTICE

WORK ORDER
NO. 22089

RELEASED
00.07.18

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D2952-041 BASKET
LID ASSEMBLY

AN4-22A BOLT (1)
AN960JD416LWASHER (1) ~~RF~~ 05.10.06
AN970-4 WASHER (2)
MS21042L4 NUT (1)

D2948-041 BASKET
BASE ASSEMBLY

PROP ARM DETAIL

SEE DETAIL B

D2332-041 LID
PROP ASSEMBLY

AN4-14A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)
(2 PLACES)

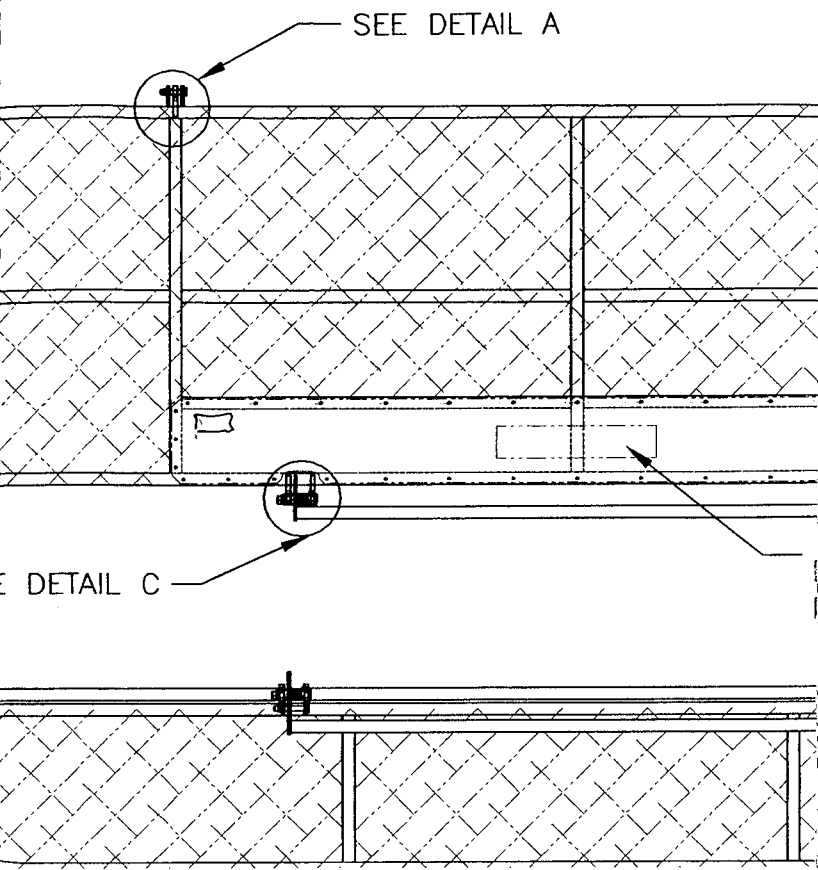
D2931 BUMPER (1)
MS20600AD4W3 (1)
AN960JD8 WASHER (1)
(2 PLACES)

2

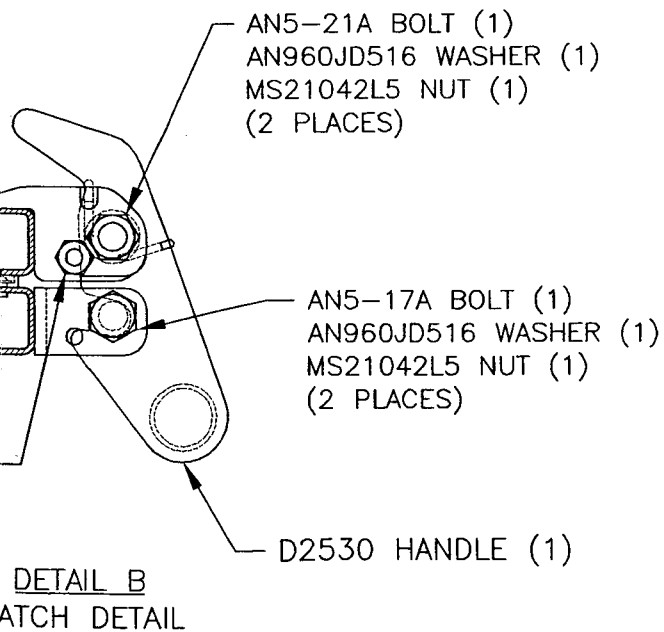
~~RF~~ 00.04.08
RF

AN3-20A BOLT (1)
MS21042L3 NUT (1)
(2 PLACES)

DETAIL A
HINGE DETAIL



D2955-041 BASKET ASSEMBLY



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DESIGN

RF

CHECKED

RF

DATE

00.07.17

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 13, 2004
11:38 am

Work Order No : 0022089
Project Name : D407-663-011
Project For : WK505
Work Order Type : Main
Main WO Number :
House Part Number : *D407-663-011
Description : Heli-Utility-Basket
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 12-10-04
Est Finish Date : 02-02-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

5/05

DART AEROSPACE LTD	Work Order:	22089
Description: 407 Basket Base	Part Number:	D2948-041
Dwg: D2948 Rev. B	Qty:	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	HA	04.12.14	1																				
2	LG	Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948 Material: 304/316 SS tube 0.049" wall (M304TS0.750W.049) Identify for D2948-5 Batch: <u>15357</u>	DP	05-9-27	1																				
3	LG	Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019	DP	05-9-27	1																				
4	WS	Trim to length as per Dwg D2948 and Deburr Identify as D2948-5	HA	05/10/03	1																				
5	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2948 Material: 304/316 SS tube 0.049" wall (M304TS0.750W.049) Identify properly as D2948-1/-3/-7/-9 Batch: <u>M16441</u>	HA	05/10/03	1																				
6	WS	Drill holes in D2948-3/-7 as per Dwg D2948. Deburr as required. <i>* REMOVE ALL MARKINGS FROM MATERIAL</i>	HA	05/10/03	1																				
7	KP	Weld as per Dwg D2948 and QSI 004. Deburr as required. Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2327-3</td><td>Spacer</td><td><u>623849</u></td></tr><tr><td>2</td><td>D2581</td><td>Mounting Bracket</td><td><u>823584</u></td></tr><tr><td>4</td><td>D2954</td><td>Mounting Plate</td><td><u>812525</u></td></tr><tr><td>32sf</td><td>M304EX0.75-16F</td><td>SS Expanded Metal</td><td><u>1415999</u></td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2327-3	Spacer	<u>623849</u>	2	D2581	Mounting Bracket	<u>823584</u>	4	D2954	Mounting Plate	<u>812525</u>	32sf	M304EX0.75-16F	SS Expanded Metal	<u>1415999</u>	HA	05/10/04	1
Qty	Part Number	Description	Batch																						
1	D2327-3	Spacer	<u>623849</u>																						
2	D2581	Mounting Bracket	<u>823584</u>																						
4	D2954	Mounting Plate	<u>812525</u>																						
32sf	M304EX0.75-16F	SS Expanded Metal	<u>1415999</u>																						
8	QC9/6	Inspect welding and dimensions	PD	05-10-05	1																				
9	WS	Go to traveler D407-663-011 for Finishing	SP	05/10/04	1																				

Rev	Date	Change	Revised By	Approved
A	00.03.22	New Issue	EC	
B	00.08.09	New dwg rev (mpp2078)	EC	
C	00.11.21	Added D2948-5 to pick list	EC	
D	03.11.26	Reformat; Incorporated D2948-5	KJ/RF	
E	04.08.09	Revised Step 2	KJ/JLM	

RELEASED

04/04-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5/05

DART AEROSPACE LTD	Work Order:	22089
Description: 407 Basket Lid	Part Number:	D2952-041
Dwg: D2952 Rev. B	Qty:	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	KA	04.12.14	1																				
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2952 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall (M6061T6TS0.750W.062) Identify as D2952-1/-3/-5/-7/-9 Batch: <u>M 9671</u>	MA	05/10/03	1																				
3	WS	Cut D2952-11 corner gussets as per Dwg D2952 Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080" (M5052H32S.080) Batch: <u>M 16241</u> Identify as D2952-11	MA	05/10/03	1																				
4A	WS	Drill holes in D2952-3 as per Dwg D2952. Deburr.	MA	05/10/03	1																				
4B	WS	REMOVE ALL MARKINGS FROM MATERIAL.	MA	05/10/03	1																				
5	WS	Weld as per Dwg D2952 as per QSI 004. Deburr as required. Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2953-077</td><td>Spacer</td><td><u>A13267</u></td></tr><tr><td>1</td><td>D2953-175</td><td>Spacer</td><td><u>B22096</u></td></tr><tr><td>6</td><td>D2957</td><td>Mounting Plate</td><td><u>B21198</u></td></tr><tr><td>15sf</td><td>M1100H14ES-3/4x.051F</td><td>Mesh</td><td><u>M17390</u></td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2953-077	Spacer	<u>A13267</u>	1	D2953-175	Spacer	<u>B22096</u>	6	D2957	Mounting Plate	<u>B21198</u>	15sf	M1100H14ES-3/4x.051F	Mesh	<u>M17390</u>	MA	05/10/04	1
Qty	Part Number	Description	Batch																						
2	D2953-077	Spacer	<u>A13267</u>																						
1	D2953-175	Spacer	<u>B22096</u>																						
6	D2957	Mounting Plate	<u>B21198</u>																						
15sf	M1100H14ES-3/4x.051F	Mesh	<u>M17390</u>																						
6	QC9/6	Inspect welding and dimensions	PD	05.10.04	1																				
7	FP	Chemical Conversion Coat as per QSI 005 4.1	MA	05/10/04	1																				
8	QC3	Inspect Conversion Coat	PD	05.10.04	1																				
9	GA	Assemble Label Plate as per Dwg D2952 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2983</td><td>Label Plate</td><td><u>B13268</u></td></tr><tr><td>34</td><td>MS20600AD4W2</td><td>Rivet</td><td><u>M4747</u></td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2983	Label Plate	<u>B13268</u>	34	MS20600AD4W2	Rivet	<u>M4747</u>	MA	05/10/05	1								
Qty	Part Number	Description	Batch																						
1	D2983	Label Plate	<u>B13268</u>																						
34	MS20600AD4W2	Rivet	<u>M4747</u>																						
10	QC5	Inspect work to Step 9	PD	05-10-05	1																				
11	GA	Go to traveler D407-663-011 for Finishing	SB	05/10/06	1																				

Rev	Date	Change	Revised By	Approved
A	00.03.22	New Issue	EC	
B	00.07.12	Up dated Dwg rev.B	EC	
C	03.11.26	Reformat	KJ/RF	RF

RELEASED
04.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

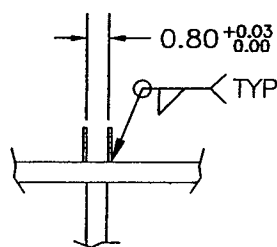
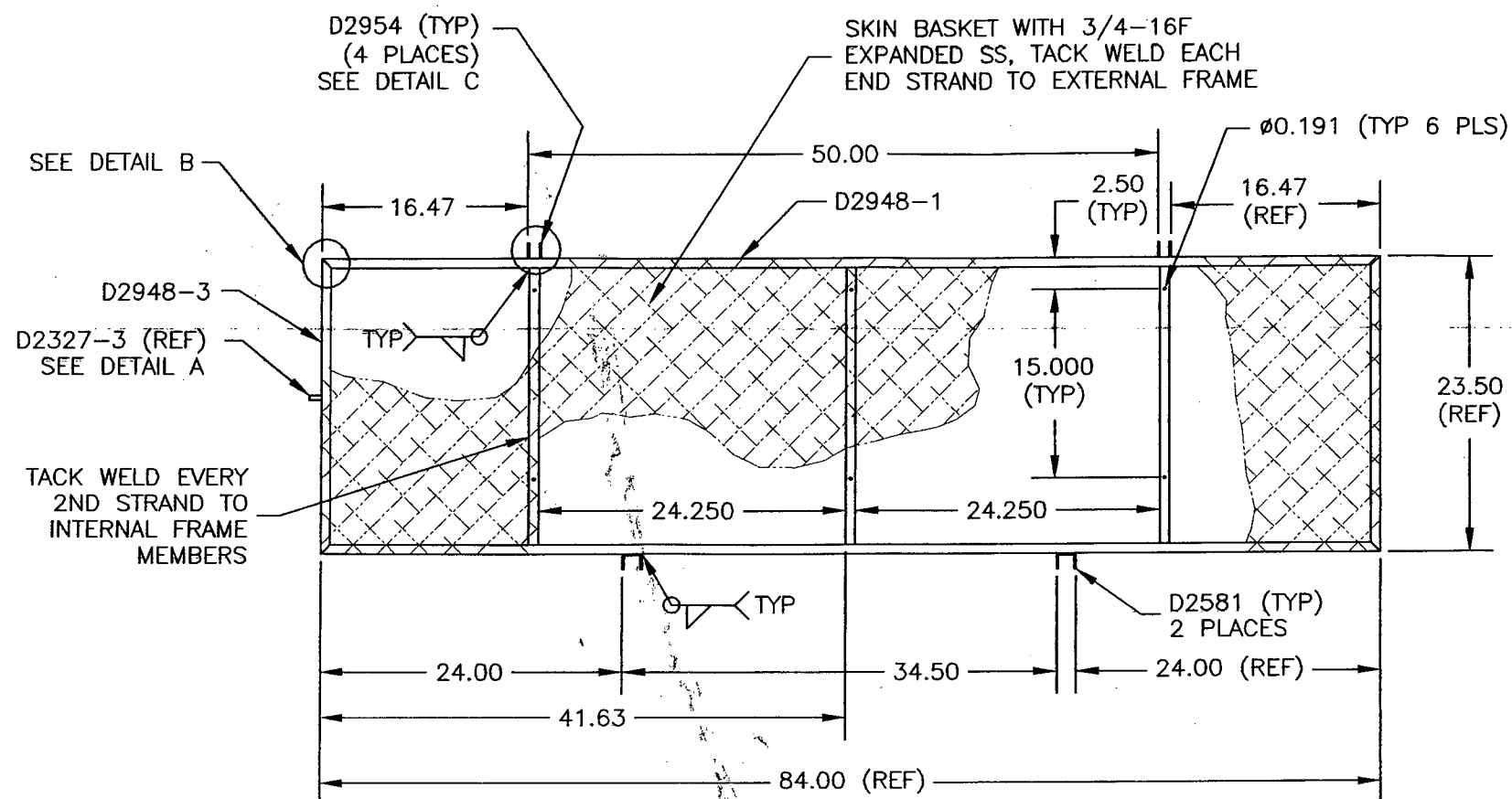
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

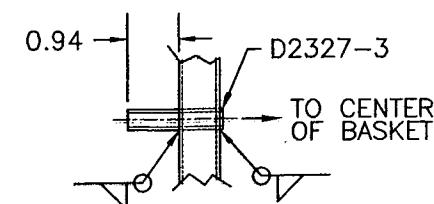
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

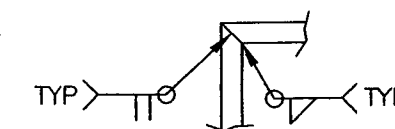
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00.07.18



DETAIL C



DETAIL A
SPACER INSTALLATION

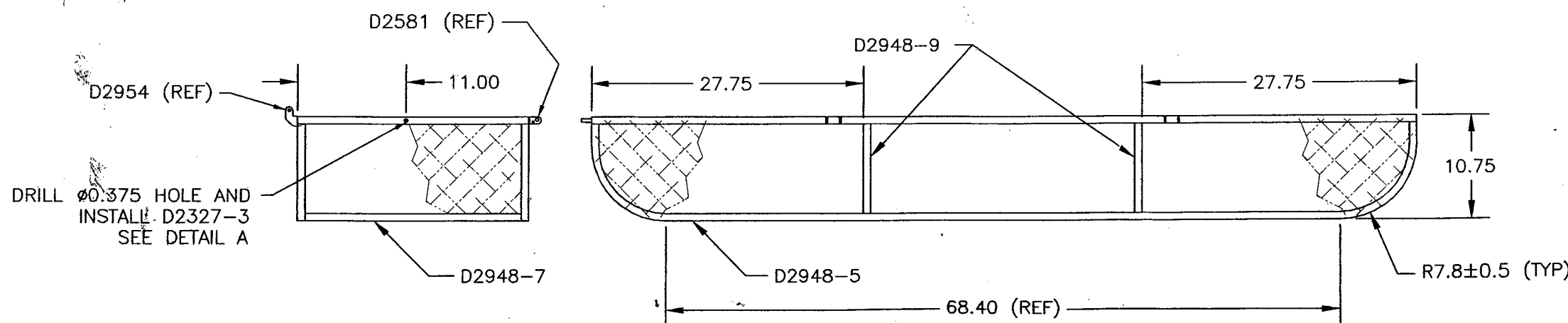
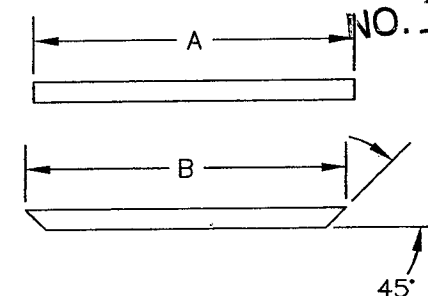


DETAIL B
WELD ALL JOINTS
AS SHOWN

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WITHOUT NOTICE

WORK ORDER

NO. 22089



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
-041				
X	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING
MESH MATERIAL: 3/4-16F EXPANDED SS
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
WELD PER DART QSI 004
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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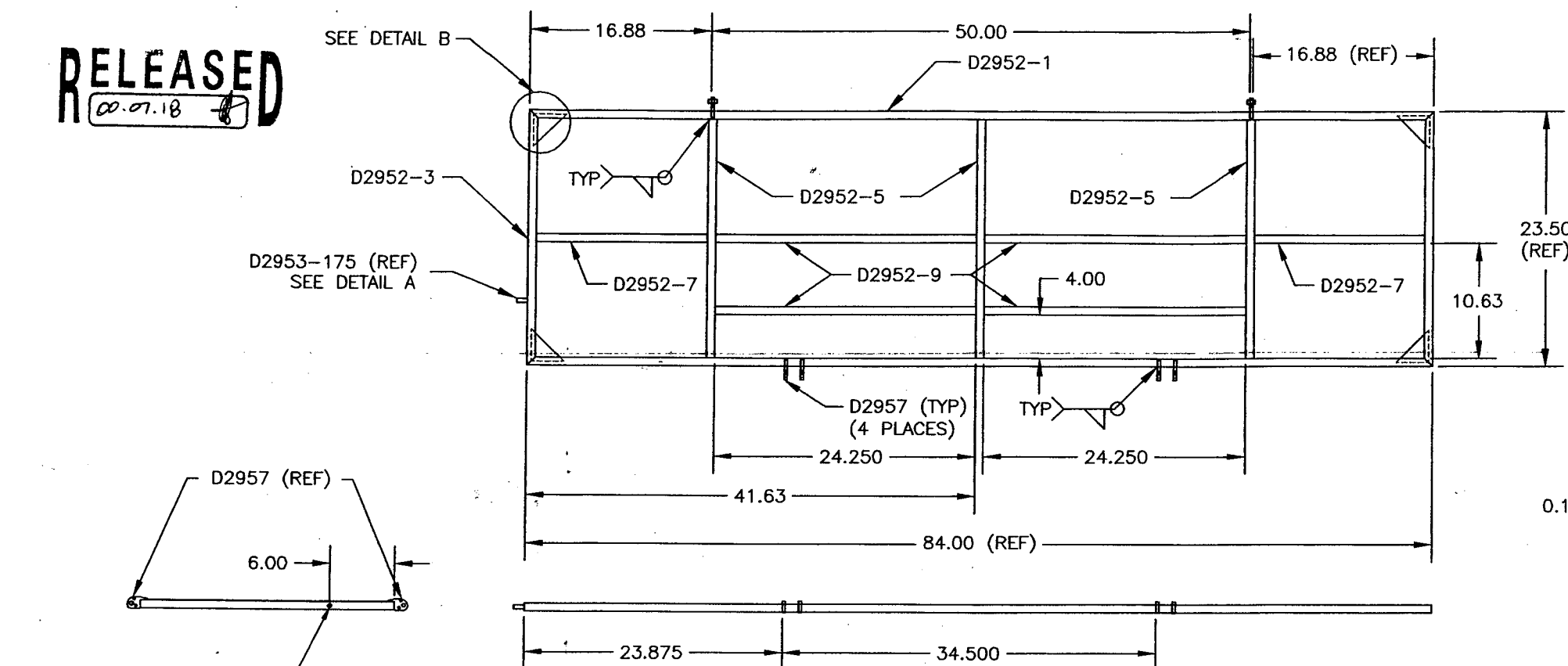
B	00.07.17	ADD Ø0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY
CHECKED	RF	APPROVED
DATE	00.07.17	TITLE
		BASKET BASE ASSEMBLY
		SCALE
		NTS

DART

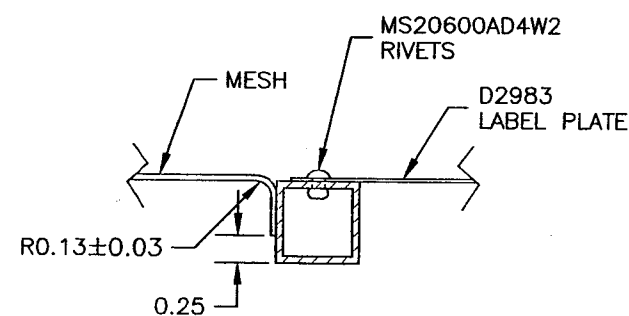
DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

REV. B
SHEET 1 OF 1

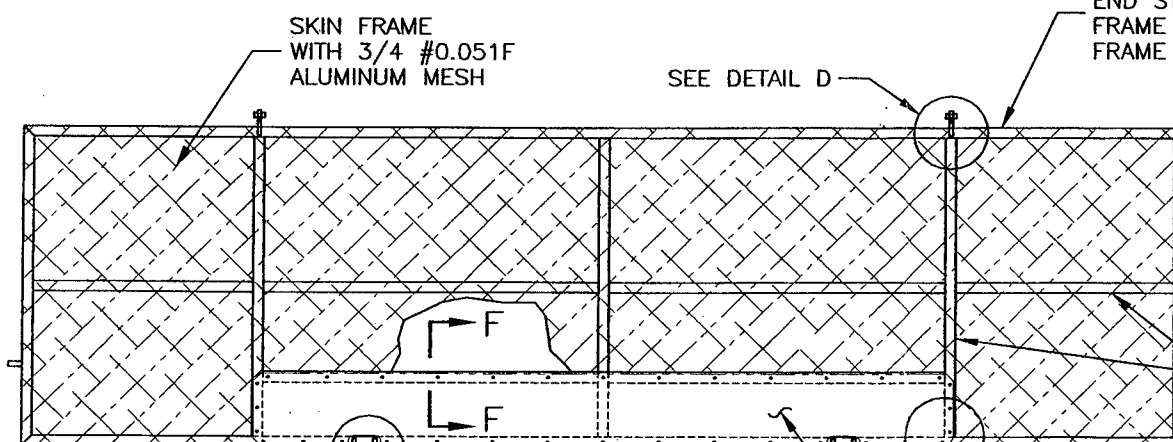
RELEASED
00.07.18



DRILL $\phi 0.375$ HOLE
AND INSTALL D2953-175
SEE DETAIL A

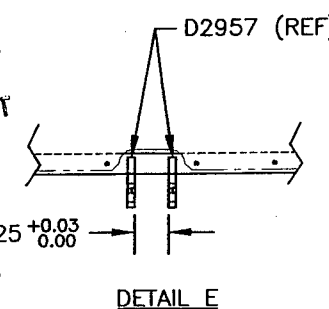
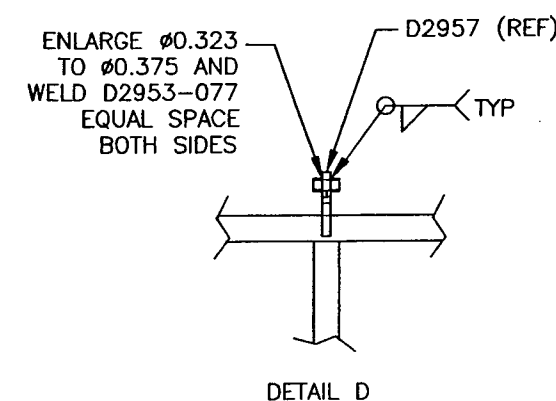
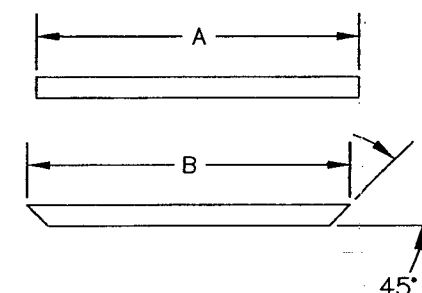
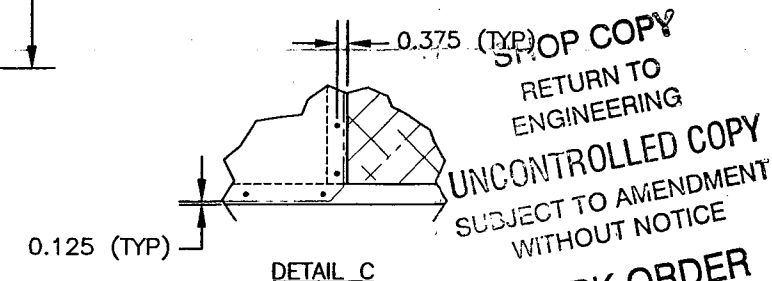
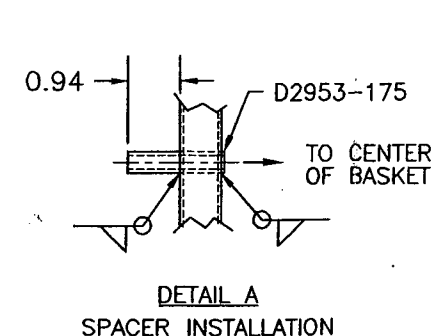


SECTION F-F

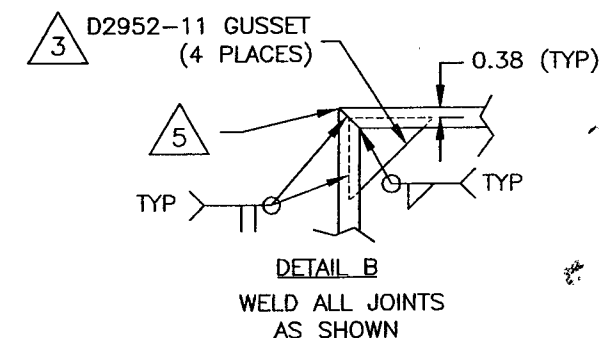


TACK WELD EACH
END STRAND TO
FRAME ON OUTSIDE
FRAME MEMBERS

TACK WELD EVERY
2ND STRAND TO
INTERNAL FRAME
MEMBERS



STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22089



NOTES:

- 1) FRAME MATERIAL: 6061-T6, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING (QQ-A-200/8 OR QQ-A-225/8)
- 2) MESH MATERIAL: 5005-H34 OR 3003-H14 OR 1100-H14/H18 3/4 #0.051F
- 3) GUSSET MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32/H34 (QQ-A-250/8) (3.00 x 3.00) 0.080 THICK
- 4) WELD PER DART QSI 004
- 5) GRIND 0.063 MAX x 45° CHAMFER BEFORE WELDING CORNERS (TYP. 4 PLACES)
- 6) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE, GRIND CORNER WELDS (4 PLS) BOTTOM SIDE FOR GUSSET
- 7) TRANSFER D2983 LABEL PLATE HOLES USING $\phi 0.128$ DRILL. INSTALL D2983 ONTO FRAME USING MS20600AD4W2 RIVETS (TYP. 34 PLACES)
- 8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

QTY	PART	DESCRIPTION	LENGTH	LENGTH
-041	NUMBER		A	B
X	D2952-041	BASKET LID ASSEMBLY	N/A	N/A
2	D2952-1	FRAME MEMBER	N/A	84.00
2	D2952-3	FRAME MEMBER	N/A	23.50
3	D2952-5	FRAME MEMBER	22.00	N/A
2	D2952-7	FRAME MEMBER	15.88	N/A
4	D2952-9	FRAME MEMBER	24.25	N/A
4	D2952-11	GUSSET	N/A	N/A
1	D2953-175	SPACER	N/A	N/A
2	D2953-077	SPACER	N/A	N/A
6	D2957	MOUNTING PLATE	N/A	N/A
1	D2983	LABEL PLATE	N/A	N/A
34	MS20600AD4W2	RIVETS	N/A	N/A

B	00.07.06	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11
A	00.01.14	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED RF	APPROVED RF	DRAWING NO. D2952
DATE 00.07.06		REV. B SHEET 1 OF 1 SCALE BASKET LID ASSEMBLY NTS

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